

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 143885

March 28, 2016 9:52:05 AM

143885

Page 2

Item ID: D3136-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Window Assembly
Start Date: 3/29/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/6/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo 1-Thermoform as per Dwg D3136 and Work Instruction WI006 Dwg Rev. <u> F. F. Wk </u> WI Rev. <u> E. K. Sh </u> 2- Engrave Part # and Batch # , and affix labels (D3108-9)	0.00 0.02				<u> 76 </u>			DAS 07 9-89 16/04/06
150 *150* HandThermo Hand Finishing Thermoforming	HAND FINISHING THERMOFORMING Memo Water sand and buff to remove scratches as required	0.00 0.02				<u> 76 </u>			DAS 07 9-89 16/04/06

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OTHER : ☐									

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143885

Page 3

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 Revision ID: Stop ***NS2***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Quality Control

Memo

Inspect edge and window deformation, wrap in plastic

0.00

180

Identify as per dwg & Stock Location: ~~8447~~ *8442 X2*

0.00

180

Packaging

Packaging

Memo

Sold X2

0.00

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Quality Control

Memo

0.01

26

6x Sp16-04-16

MLJ

APR 06 2016

MLJ

APR 06 2016

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OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 143885

143885

Parent Item: D3136-045

D3136-045

Parent Item Name: Window Assembly

Start Date: 3/29/2016

Required Date: 4/6/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:C 15.02.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3108-9

Manufactured

No

Each

210.0000

12

DAS

07

9-89

D3108-9

**

Decal

Location

Loc Qty

Loc Code

ST017

210

138645

210

sf

134.7670

12

26.84211

16/04/04

MACRLICS.125

Purchased

No

sf

134.7670

**

MACRI ICS 125

1/8" Polycast II Sheet

Location

Loc Qty

Loc Code

MAT019

134.767

m130047

22.667

m131524

55.1

m132799

8.7

m133510

48.3

27

26/04/04

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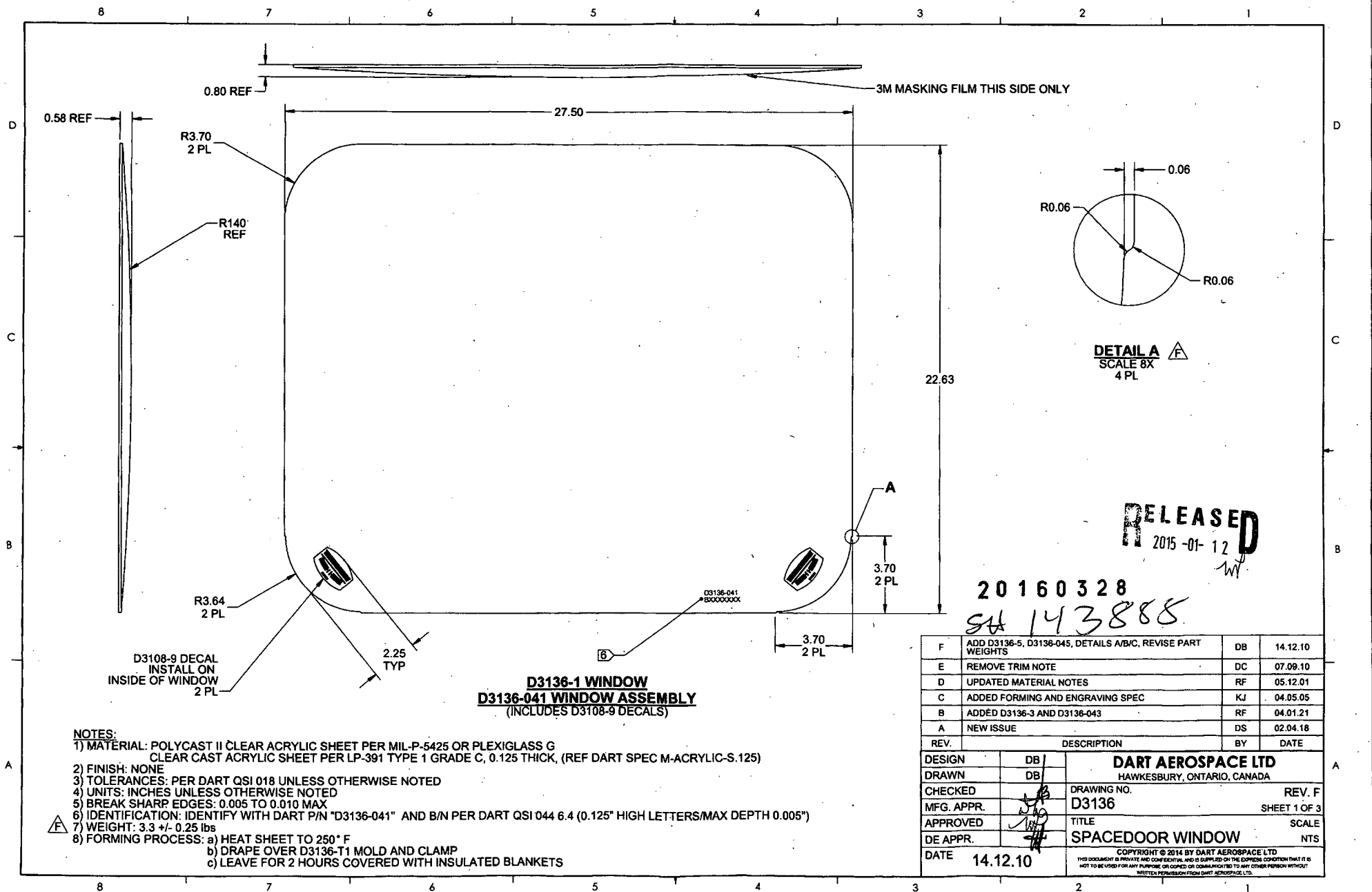


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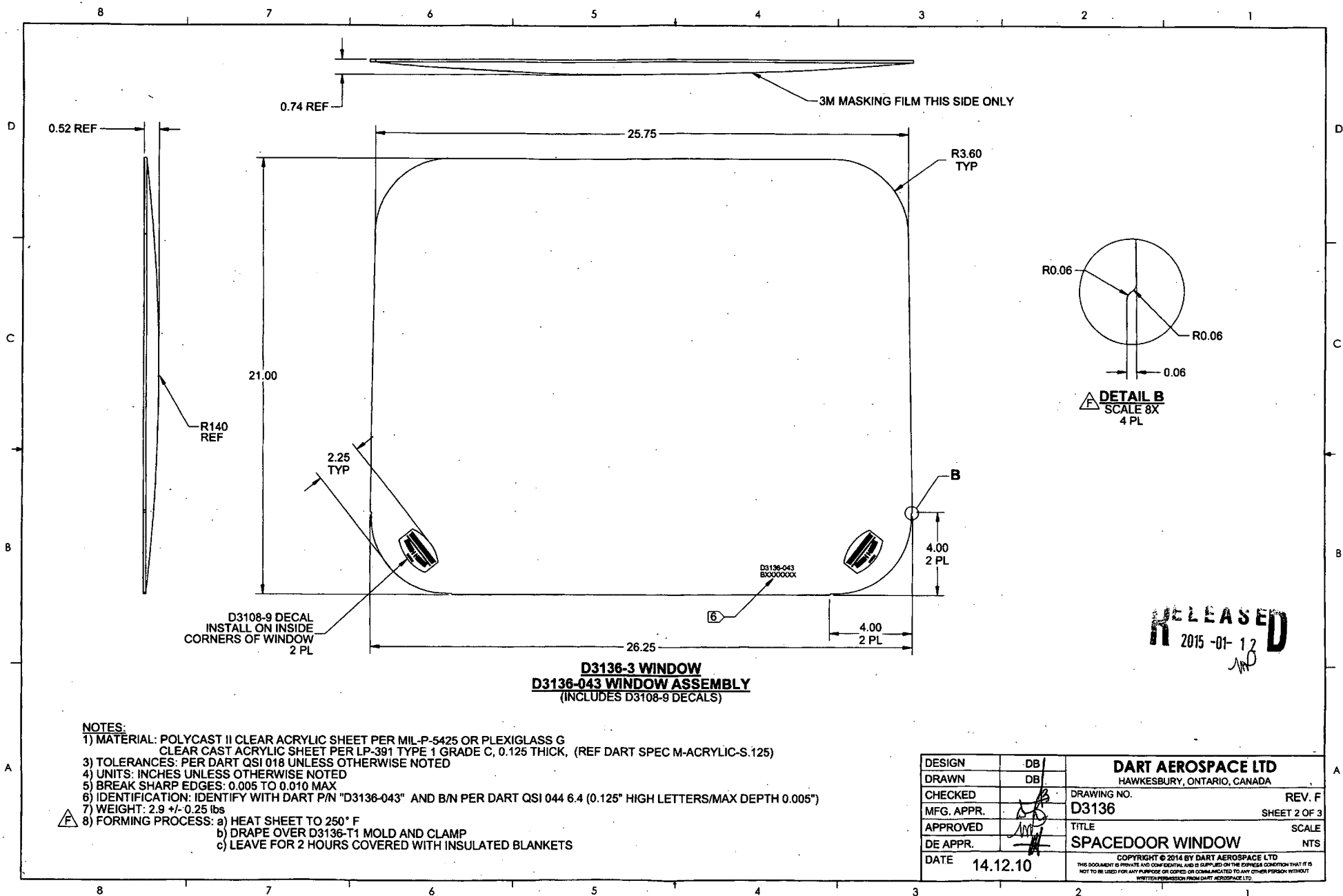
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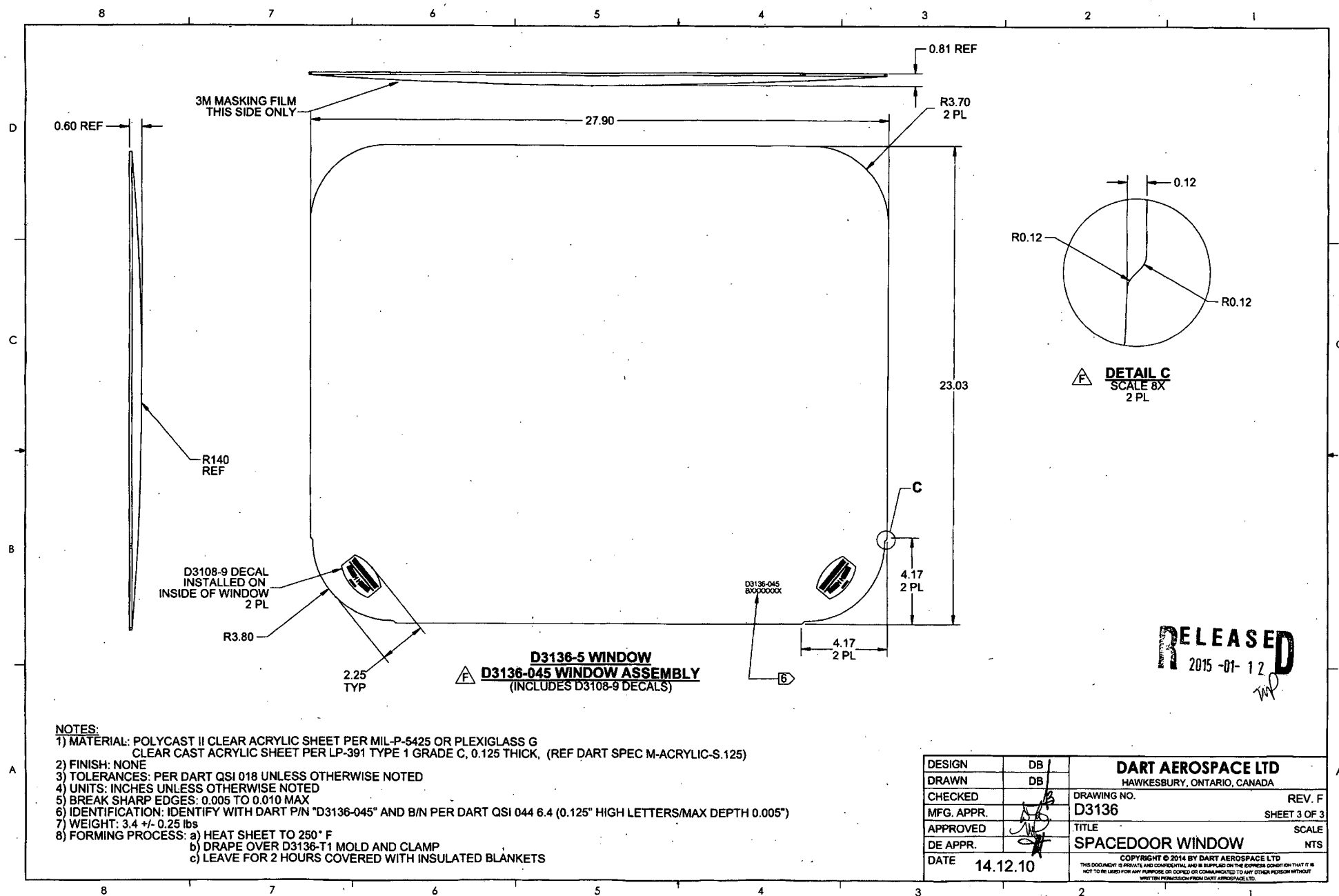


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OTHER : ☐					



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLASS G
 CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK, (REF DART SPEC M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3136-045" AND B/N PER DART QSI 044 6.4 (0.125" HIGH LETTERS/MAX DEPTH 0.005")
- 7) WEIGHT: 3.4 +/- 0.25 lbs
- 8) FORMING PROCESS: a) HEAT SHEET TO 250° F
 b) DRAPE OVER D3136-T1 MOLD AND CLAMP
 c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DB	DRAWING NO.	REV. F
MFG. APPR.	DB	D3136	SHEET 3 OF 3
APPROVED	DB	TITLE	SCALE
DE APPR.	DB	SPACEDOOR WINDOW	NTS
DATE	14.12.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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